

PATENT ABSTRACTS OF JAPAN

(11)Publication number : 57-169097

(43)Date of publication of application : 18.10.1982

(51)Int.Cl.

C25D 5/08

C25D 7/04

(21)Application number : 56-052471

(71)Applicant : HITACHI CABLE LTD
HITACHI LTD

(22)Date of filing : 09.04.1981

(72)Inventor : YAMAGISHI RYOZO
YOSHIOKA OSAMU
ISHIKAWA TETSUO

(54) PLATING METHOD OF LONG PIPE

(57)Abstract:

PURPOSE: To plate a long pipe advantageously by use of a low lift head pump, by setting the installation surface of a plating liquid storage tank and the surface of a plating liquid to a higher position than the pipe bottom part of a vertical long pipe to be plated, and making the plating liquid circulate between said storage tank and the long pipe.

CONSTITUTION: Plural zircaloy pipes 1 are vertically erected in a pit whose depth is, for instance, 3m, are covered with a heat insulating material 2, and are fixed to a mount 3. On the other hand, an installation surface 6 of a plating liquid storage tank 4 and a plating liquid surface 7 are positioned higher than a pipe bottom part 8. In this state, a chemical copper plating liquid 11 in the storage tank whose temperature is controlled by a heater 9 and a thermostatic oven 10 at 50W60°C is sucked up by a circulating pump 5, and is supplied to a plating liquid distributing case 13 through a T pipe. Subsequently, a plating liquid distributed to plural routes by the distributing case 13 is fed to the pipes 1, copper is deposited by making it contact with the pipes, the plating liquid discharged from the pipes 1 is returned to the storage tank 4 through a plating liquid collecting case 15. In this regard, the left head required for the pump 5 is a distance which has subtracted height of the liquid surface 7 from height of a pipe 1 end connecting jig 14b, and that of comparatively low pressure is also available.

